

Work Order ID 52975



Page 1

October 20, 2009 10:15:54 AM

Item ID: D119-646-243
 Revision ID: B
 Item Name: Replacement Float Skidtube w/ Training Wearplates

Accept



Setup Start



Stop



Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date:

09/10/20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3905	B								
IIN-D119-646	B								

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D119-646-243
 CHG 001

N/A *[Signature]*

Work Order ID 52975

October 20, 2009 10:15:54 AM



Page 2

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

0.00

Skidtubes

Memo

1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905

2- Cut FWD end of tube as per dwg D3905.

3- Cut AFT end of tube as per dwg D3905.

4- Buff out marks left from bending

5- Drill Aft cap pilot hole using DT8149 ***DO NOT OPEN TO FINISHED SIZE***

6- Cleco DT8149 in position and install drill Jig DT _____ drill X-bolt spacer pilot holes using 3/16" drill

7- Spot drill holes to section G using #30 drill.

8- Drill FWD cap holes using DT8215. Open FWD & AFT capholes to 0.208"

9- Drill FWD holes

10- Drill Tow ring hole using DT _____. Open to finished size.

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 3

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

See
attached
w/ sheet.

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 4

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start





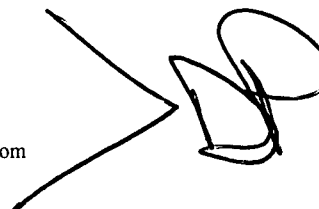
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Skidtubes	Memo 1-Open crossbolt spacer holes to finished size ***DO NOT OPEN SPOT DRILLED HOLES IN SECTION G*** 2-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube	0.00 0.00							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							



SEE ATTACHED SHEET 1

5/11/12

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 5

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Bond web in place as per Dwg D3905 & QSI 015.

A/R ☐ Sikaflex-291 ☒ M112391 ☐

Sikaflex expire date: ☐ 2010/02/30

Start: ☐ 9-10-22 ☐ Time: ☐ 830 ☐

Finish: ☐ ☐ Time: ☐

***** (Adhere for 12 hours) *****

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position.

3- Buff out marks left from bending.

4- Open holes of section G (spot drilled holes) to finished size.

*****VERIFY DIMENSIONS*****

5- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

W 9/11/5

9

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 7

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 ⇒ 8 or 1/16							
210 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00 ⇒ 8 or 1/16							
220 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00 ⇒ 11 09/11/12							

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 8

Item ID: D119-646-243
Revision ID: B
Item Name: Replacement Float Skidtube w/ Training Wearplates

Accept



Setup Start



Stop



Start Date: 20/10/2009 Start Qty: 1.00
Required Date: 02/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 Powdercoat Powder Coating	M112148 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START: 10:30AM Temp: 320g FIN: 11:00AM	0.00 0.00	=> BR	09/11/17		(X1)	0		
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR	09-11-18		①.			
250 HandFinish Hand Finishing	Memo 1-Install inserts as per Dwg D3905.	0.00 0.00	BR	09-11-18		①.			

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 9

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00



278 or 1/18

QC

Memo

0.00



f

Quality Control

270

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers.

A/R ☐ Sikaflex-240/-291 ☒ 11/12/39H

Sikaflex expire date: ☐ 10/30

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-240/-291 ☒ 11/12/39H

Sikaflex expire date: ☐ 10/30

BR 09-11-19 D

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 10

Item ID:	D119-646-243	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Replacement Float Skidtube w/ Training Wearplates					
Start Date:	20/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27	Scal/19					
285 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch Memo	0.00 0.00		BR 09-11-19					
286 QC Quality Control	QC3 Inspect Part Finish QC5 Memo	0.00 0.00	27	Scal/19					

Work Order ID 52975

October 20, 2009 10:15:55 AM



Page 11

Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

Identify as per dwg & Stock Location: _____

0.00

PP 51854

9/11/20 RD SP



Packaging

Memo

0.00

Packaging

300

QC21- Final Inspection - Work Order Release

0.00

09/11/25 AJ



QC

Memo

0.00

Quality Control

MF 09-11-20

Picklist Print

October 20, 2009 10:16:00 AM

Page 1

Work Order ID: 52975

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates



Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R 		Manufactured	No			110	Each	0.0000	1.0000			
Ext'n - I' Beam Tube 4"												
D3885-3RevB 		Manufactured	No			170	Each	1.0000	1.0000			
Standard Web												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51844

1

1

190

Each

126.0000

12.0000

D3903-1RevB

Manufactured

No



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

51849

126

126

12

8E09/11/10

Picklist Print

October 20, 2009 10:16:01 AM

Work Order ID: 52975

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3681-1RevA		Manufactured	No			190	Each	89.0000	8.0000			
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

20

51920

20

Main Warehouse

ST

69

47123

13

48178

56

D3683-3RevB

Purchased

No

250

Each

0.0000

12.0000

Insert

ALS4-1032-130

Purchased

No

250

Each

5,373.000

10.0000

Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

D2855-3RevB

Manufactured

No

270

Each

0.0000

2.0000

Cap

47805

52281

8 BE 09/11/14

12 BR-09-11-18

10 BR-09-11-18

2 BR-09-11-19

Picklist Print

October 20, 2009 10:16:01 AM

Work Order ID: 52975

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	2,054.000	4.0000			
												
Phenolic Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1554	
39275	19	
42329	13	
47628 ✓	522	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

4 10/09-11/09

D3846-1RevB

Manufactured No

270

Each

10.0000

1.0000



GASKET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
51827 ✓	10	

1 10/09-11/09

Picklist Print

Page 4

October 20, 2009 10:16:01 AM

Work Order ID: 52975

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-11RevB		Manufactured	No			270	Each	20.0000	1.0000			

GASKET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	20	
51833 ✓	20	

1 10/11/09

D3847-1RevB

Manufactured No



WEARPAD

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	35	
51823 ✓	35	

1 10/11/09

D3847-11RevB

Manufactured No



WEARPAD

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	19	
51824 ✓	19	

1 10/11/09

D3849-047RevB

Manufactured No



WEARPLATE

51837

1 10/11/09

October 20, 2009 10:16:01 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

October 20, 2009 10:16:01 AM

Work Order ID: 52975

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3849-045RevB		Manufactured	No			270	Each	0.0000	1.0000			
AFT WEARPLATE ASSY, FLOATGEAR												
D3904-1RevB		Manufactured	No			270	Each	300.0000	16.0000			
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST136

51875

300

300

270

Each

659.0000

12.0000

D3672-3RevB

Manufactured

No



Phenolic Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

159

34471

8

48258

151

Main Warehouse

ST117

500

51596✓

500

October 20, 2009 10:16:01 AM

Shop Packet Print

Page 5

Picklist Print

Page 6

October 20, 2009 10:16:01 AM

Work Order ID: 52975



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			270	Each	714.0000	14.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	714	
111424	8	
111707	69	
112314	7	
112489	100	
112641 ✓	500	
112720	30	

14 11-11-19

AN3C46A



BOLT

Purchased

No

270

Each

93.0000

4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	93	
106169	5	
106176	9	
111918 ✓	79	

4 11-11-19

Picklist Print

Page 7

October 20, 2009 10:16:01 AM

Work Order ID: 52975



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			270	Each	5,216.000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	5116	
1121161 ✓	926	
112612 ✓	3190	
112933	1000	

10 02-11-19

AN960C416



washer

Purchased

No

270

Each

703.0000

12.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	703	
100993 ✓	703	

12 02-11-19

Picklist Print

Page 8

October 20, 2009 10:16:01 AM

Work Order ID: 52975



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3 		Purchased	No			270	Each	5,119.000	8.0000			
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5039	
111819	78	
112243	39	
112314 ✓	4922	

MS27039C4-08

Purchased

No

270

Each

117.0000

12.0000



SCREW

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	117	
17831 ✓	117	

8 10-11-19.

12 10-11-19.

Picklist Print

October 20, 2009 10:16:01 AM

Work Order ID: 52975



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C50A 		Purchased	No			270	Each	78.0000	4.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	78	
112046	5	
112454 ✓	23	
112761	50	

4 16/09-11-19.

D3411-3RevREVA

Manufactured

No

270

Each

90.0000

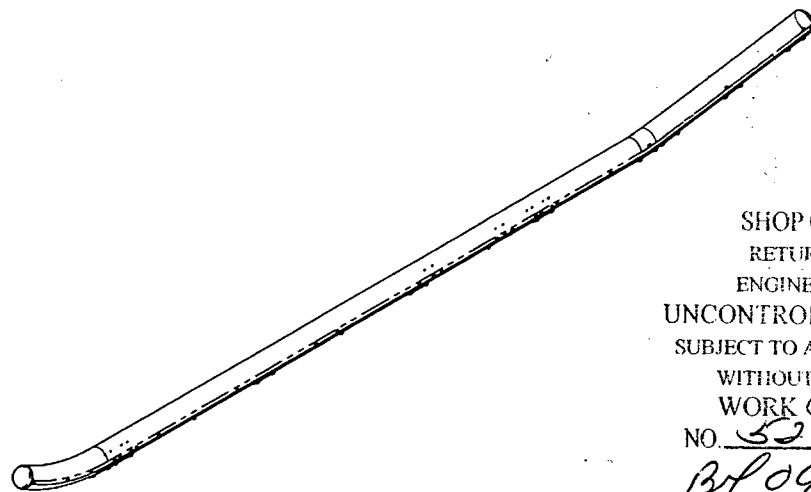
16.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	90	
51635 ✓	50	
52597	40	

16 16/09-11-19.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *52975*
B709-10-20

D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

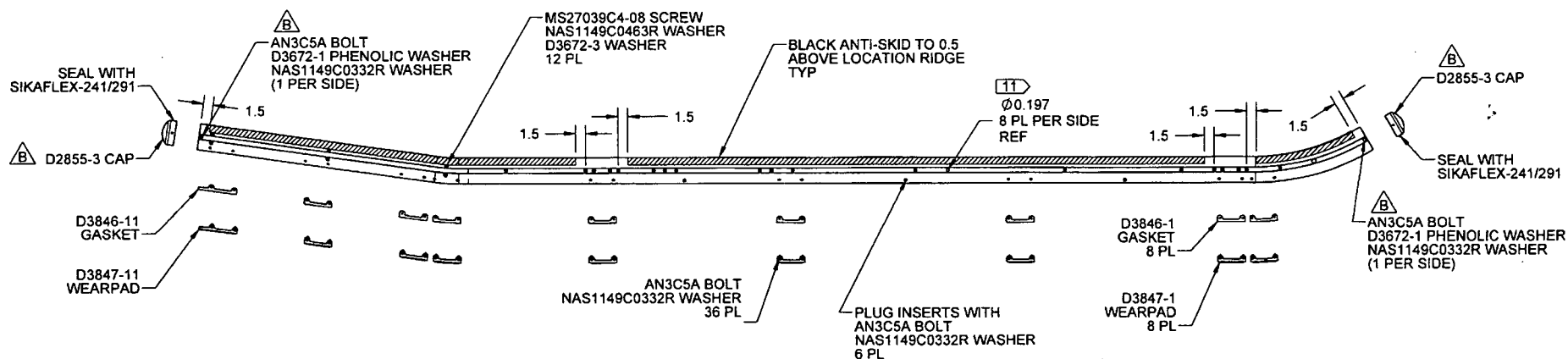
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs
D3905-043 = 47.0 lbs
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS.
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED
09/17/15

B	REVISED PART LIST. ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.315 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE IV (ZN A6-7)		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>[Signature]</i>	D3905	SHEET 1 OF 8	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	A119 FLOAT SKIDTUBE ASSY	NTS	
DATE	09.06.30		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

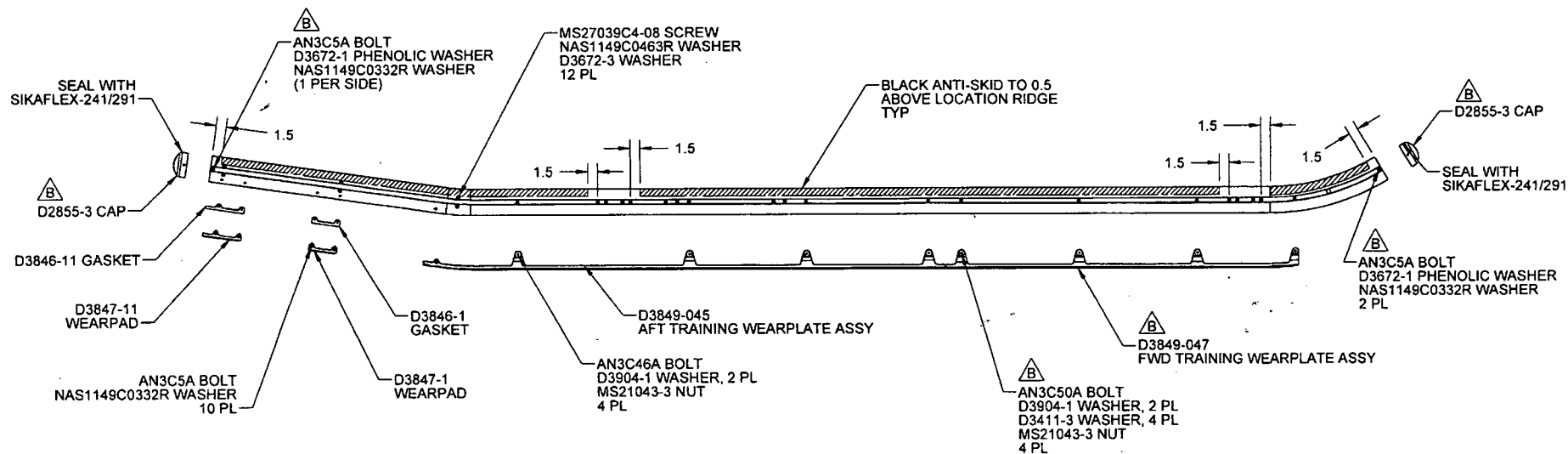


D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3905-11 SKIDTUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52975

RELEASED
10/15/00

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3905	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

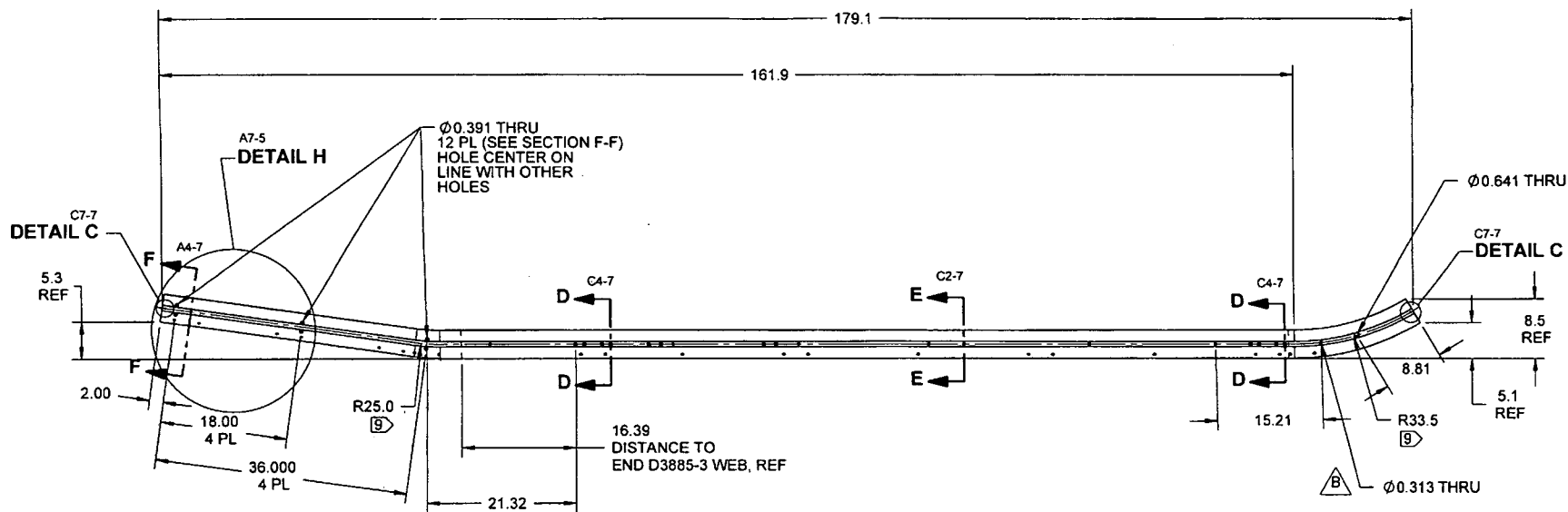


D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3905-13 SKIDTUBE)

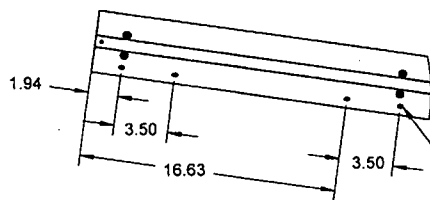
RELEASED
12/15/14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52975

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)



DETAIL H C7-5
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52925

RELEASED
09/07/15 AM

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

A7-6
DETAIL G

C7-7
DETAIL C

5.3
REF

2.00

18.00
4 PL

36.00
4 PL

R25.0

21.32

16.39
DISTANCE TO
END D3885-3 WEB, REF

179.1

161.9

C4-7

D

C2-7

E

C4-7

D

15.21

R33.5

9

Ø 0.313 THRU

Ø 0.641 THRU

C7-7
DETAIL C

8.5
REF

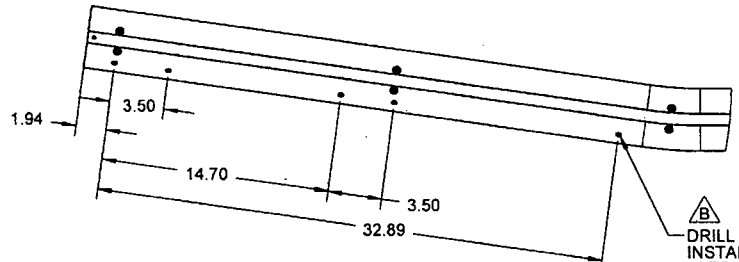
8.81

5.1
REF

D3905-13 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52975

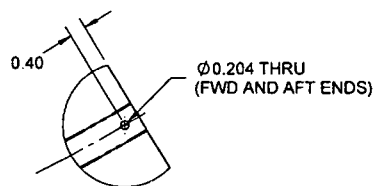
RELEASED
09/07/15 NW



DETAIL G
SCALE 2X C8-6

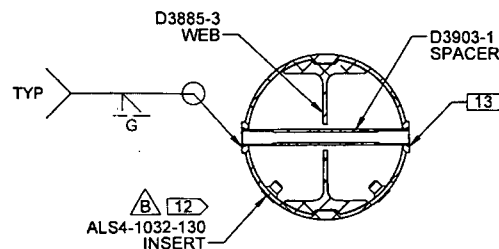
DRILL Ø 0.297
INSTALL ALS4-1032-130 INSERT
AFTER FINISH, SEE SECTION F-F
TYP. 2 PL

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3905	SHEET 6 OF 8
APPROVED	NW	TITLE	SCALE
DE APPR.	NW	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



DETAIL C
SCALE 4X

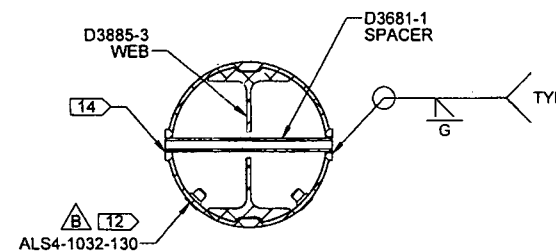
C1-5
C8-5
C8-6
C1-6



SECTION D-D
SCALE 4X

(FOR 12 x Ø0.375 HOLES
PER SKIDTUBE)

C5-5
C2-5
C5-6
C2-6



SECTION E-E
SCALE 4X

(FOR 8 x Ø0.313 HOLES
PER SKIDTUBE)

C4-5
C4-6

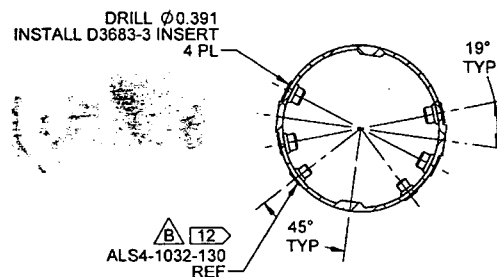
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52975

RELEASED
07/15/10

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

- i) CHAMFER HOLES Ø0.475 x 45° (BOTH SIDES)
- ii) INSERT D3903-1 SPACER
- iii) WELD INTO PLACE AND GRIND FLUSH
- iv) C'BORE TO 0.313 x 0.75 DEEP
- v) DEBURR HOLES

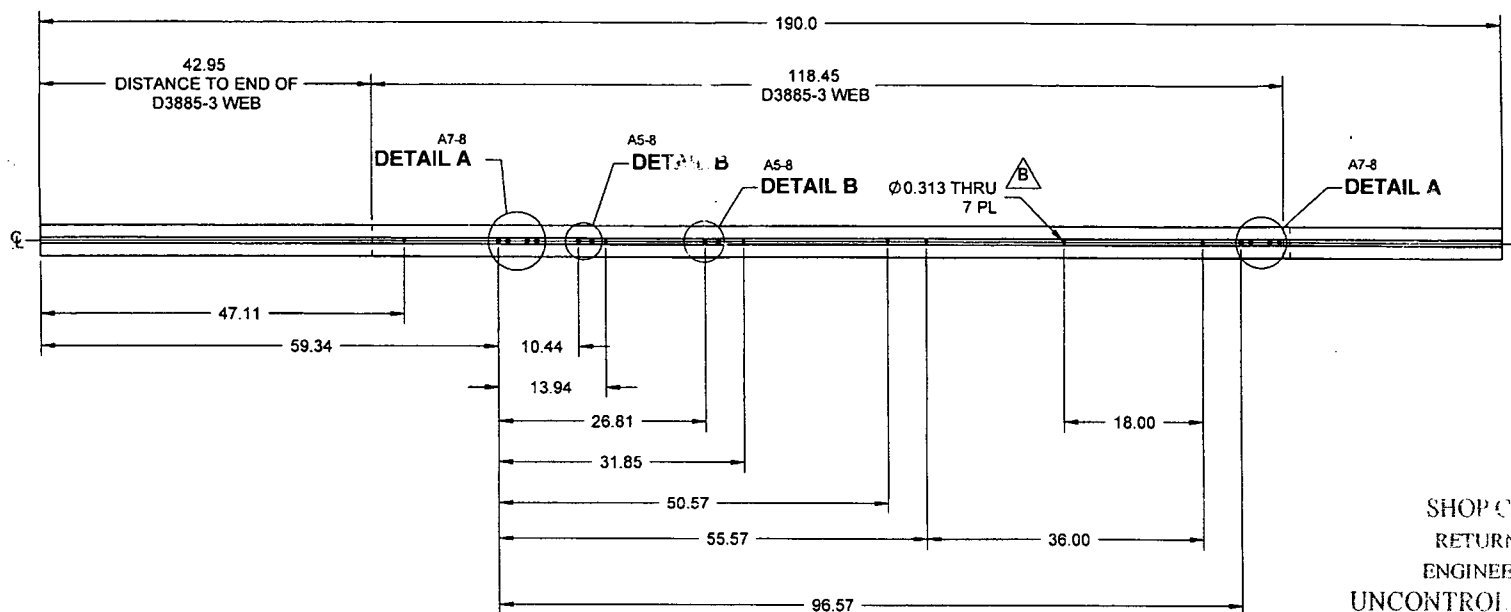


SECTION F-F
SCALE 4X

C7-6
C7-5

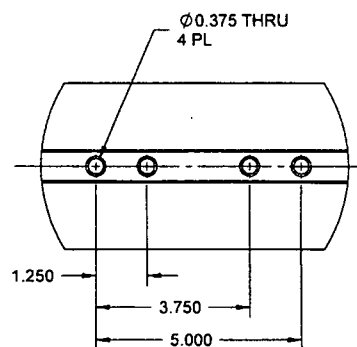
- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.313 HOLES ONLY:
- vi) CHAMFER HOLES Ø0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
- vii) INSERT D3681-1 SPACER
- viii) WELD INTO PLACE AND GRIND FLUSH
- ix) DEBURR HOLES

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

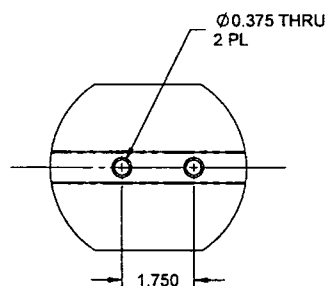


D3905-1 TUBE
(MAKE FROM D2500-1-190 EXTRUSION)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52975



DETAIL A D6-8
SCALE 4X D2-8



DETAIL B D5-8
SCALE 4X D4-8

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3905	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

B52925

9-10-20

REFERENCE ONLY

D119-646-243

Mollo 20

Seg 1
(5K10)

- 1- inspect Hat 1 D2500-1-190 for damage.
- 2- Ensure openness of ends
- 3- Chemical conversion Cent as per OSI 005 415

9-10-20

Seg 2

QC 3/2

BE 09-10-21

Seg 3
(5K10)

- 1- install drill jig DT9480 drill all x-batt
open holes using 3/16 Drill.
- 2- acibe batch # inside aft end of tube

9-10-21

Seg 3
(5K10)

- 1- Bend aft end of tube using CNC Bender 1
and bend prep D3905 Aft. Or just use
bending Aid DT9538 starts 103.25" from Aft end.

REFERENCE ONLY

- ①- Ensure Bending Aid DT 9538 is
positioned correctly, that the bender
set up in on full wide and that
the indexing ridge is covered with
Graphite grease.

9-10-21

- ② 1- Verify dimension if bend as per drawing 3905
- 2- Buff out marks left from bending
- 3- Drill Aft Flot Bog holes using DT 9493
as per drawing D3905 detail C & Section F-F
open to finished size

9-10-21

4- Drill Aft w/ coped & w/ saddle holes using
DT 9545 + DT 9544 as per drawing D3905 detail 6.
Open to finished size.

3- Open X-belt spacer holes to finished
size as per drawing 3905 (section D-D & E-E)
*** DO NOT OPEN FWD SADDLE HOLES ***

4- Debur, blowout chips from inside of tube 9-10-22

5- Bond web in place as per drawing D3905
+ OS 1015. Allow for 12 hrs.

Sika 1112 391

Exp Date 2010/02/30

Date 9-10-22

Time 8:30 AM

9-10-22

FDCS - (651112)

Seq 5
(3 and 1)

1- Bond Fwd end of tube using bond 1112
and bond prep D3905 Fwd. See Bonding
Aid DT 9544 Ensure proper positioning
2- Cut Fwd end of tube as per drawing D3905
*** Verify measurement before cutting ***
9-11-5

1- Buff out marks left from bonding

2- Drill Fwd Cap holes using DT 8215
Open Fwd + Aft Cap holes to Ø 0.308

3- Open Fwd saddle holes to finished size
as per drawing D3905

4- Drill Fwd X-belt hole + Open to finished
size (holes must be drilled out manually)

REFERENCE ONLY

11 9/11/19

491117

5- Drill four ring hole & open to finished
size Chalk must be laid out manually

7- Debur, blow out chips from inside
of tube

6- Open Alt float bag holes DO.391 as per drawing D3905
detail 6 & Section F-F
QC S/6 position

Sq 7

Sq 8
(alt)

1- Counter sink x-bolt holes as per drawing D3905

2- Remove adhesive prepare for welding & 09/11/16

3- insert x-bolt Spacers & 09/11/16

4- weld x-bolt Spacers
A/R 211230Z & 09/11/16

5- Grind welds flush

6- e' base x-bolt holes as per drawing D3905

7- Debur

} See wro 1

Sq 9 QC S/6 See wro 1

Sq 10 QC 10 See wro 1

Sq 11 → PAINT

REFERENCE ONLY

NO. 217

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 52996
Part number: D119-646-243
Description: 119 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Set. D. D. D. Date of Test Coupon 09.11.16
Welder Barday Elliott Date of Test Coupon 09.11.16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld